

Date: Friday, 5/25/2007 8:36:33 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32643
Estimate Number : 12578
P.O. Number : N/A
This Issue : 5/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : NA Type : SMALL /MED FAB
Previous Run : 31443

Drawing Name : ARM
Part Number : D3560041
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material : NA
Due Date : 6/5/2007

EFFECTIVE 07.06.05 AUTH JP
RELEASED 07.06.06 DATE JP

Written By : JP 07.05.25
Checked & Approved By : JP 07.05.25
Comment : Est Rev:A New Issue 07.05.24 EC

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M17625

M104598 x 20 J.F./SA 07.05.30

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 16.750" long

J.F./SA 07.05.30 (30)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: B
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

J.F./SA 07.06.01 (20)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./SA 07.06.01 (20)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 07/06/07 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	NO POWDER COAT NO POWDER COAT. CHEM CONV. COAT ONLY REF ATTACHED DS EMAIL	KE			UP 07.06.06 per Q51042		
07.06.27	7	PRESS FIT Gty 1 D2808 Bushing B# _____ 28600 / 32752 / 32896	6					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/07/03
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.05.30	30	1 part scrap. Wrong size endmill written on Dolo	Q51042	-change Dolo → Done Scrap: replace.	SN 07.05.30 ↓	07.06.28	Q51042	07.05.30

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

332661

SE 01-06-27

6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

Weld Rod
3104721

SE 01-06-27

6

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-06-28 (6)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 01-06-28

(6)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

01-06-28

(6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

NO POWDER COAT
SEE W/O CHANGE

POSITIVE
RECALL

See attached
e-mail.

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 01-07-03

6

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WH

SE 01-07-03

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(Signature)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/03

Job Completion



U 07-07-03

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED *U* _____ DATE *7-07-03*

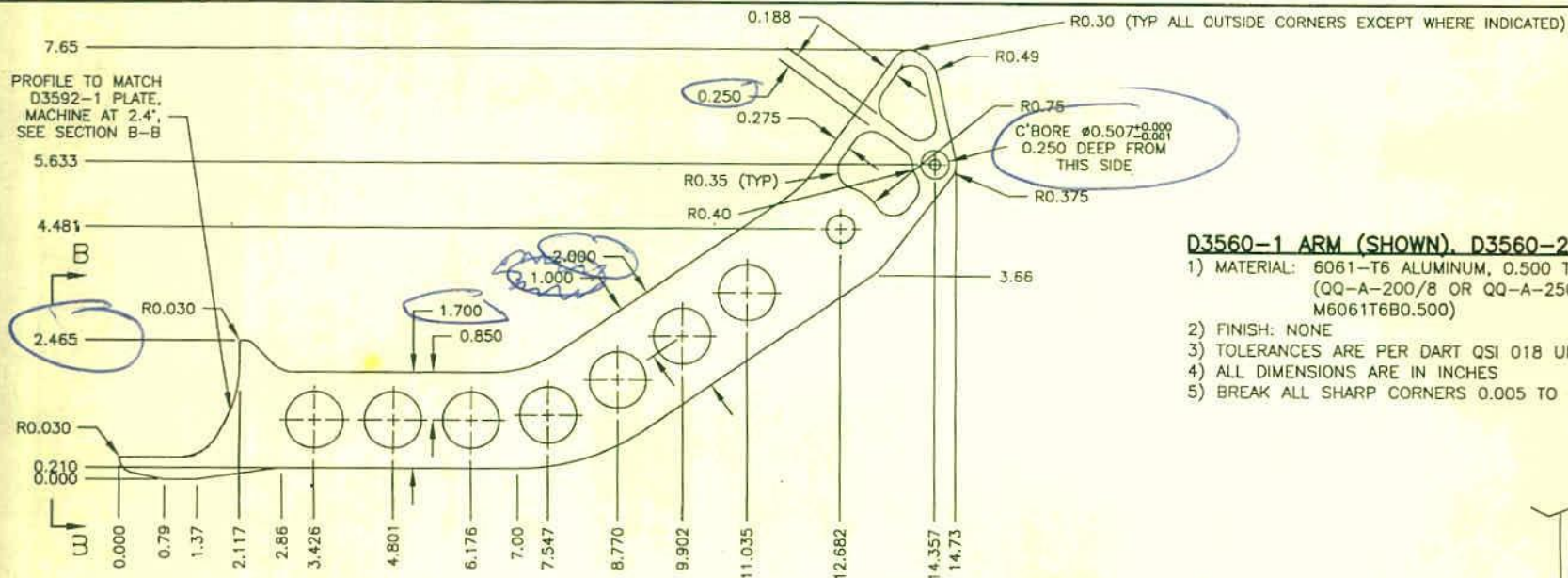
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

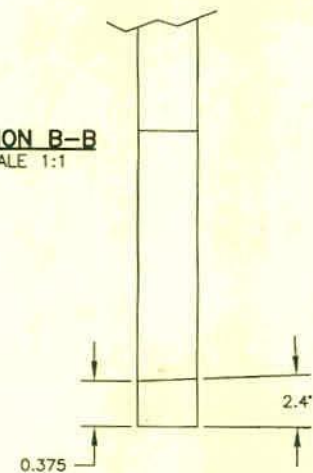
NOTE: Date & initial all entries



D3560-1 ARM (SHOWN). D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1



RELEASED

07.05.07

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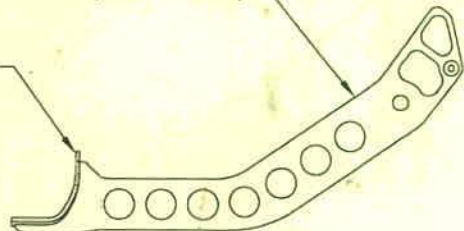
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CHECKED	#	APPROVED	#	DRAWING NO. D3560	REV. B
DATE	07.01.15	TITLE	ARM WELDMENT	SHEET 2 OF 3	SCALE 1:2

NO. 32643
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

From the
1000

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

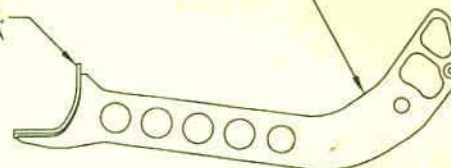
D3592-1 PLATE,
SEE DETAIL A



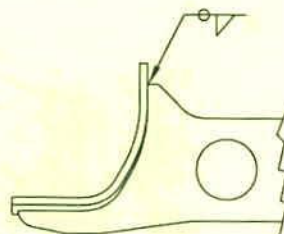
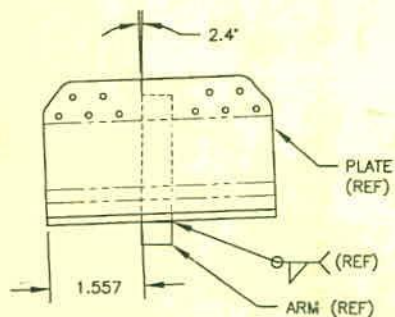
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07-05-07

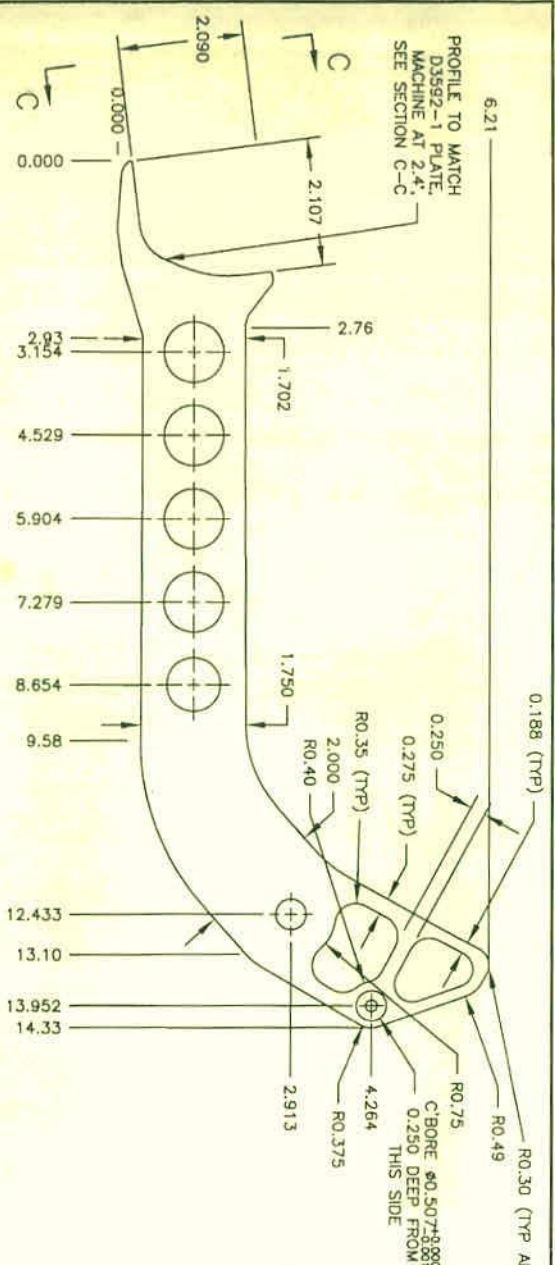
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B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	90	DRAWN BY 90
CHECKED	#	APPROVED #
DATE	07.01.15	TITLE
		ARM WELDMENT
		REV. B
		SHEET 1 OF 3
		SCALE 1:4

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WITHOUT NOTICE

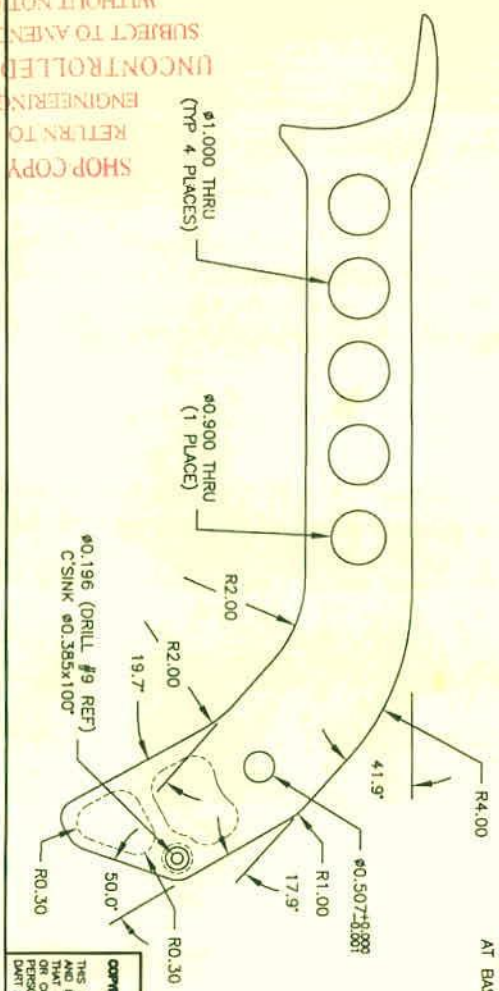
NO. 32643
 WORK ORDER
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 ENGINEERING
 RETURN TO
 SHOP COPY



- D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
 VIEW ROTATED
 SCALE 1:1



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DESIGN	40	DESIGN BY	40	DART	DART AEROSPACE LTD.
CHECKED	40	APPROVED	40	DRAWING NO.	REV. B
DATE	07/01/15			D3560	SHEET 3 OF 3
				ARM WELDMENT	SCALE

RELEASED
 07 05 07

DART AEROSPACE LTD		Work Order: 32648
Description: ARM		Part Number: 03560-1
Inspection Dwg: 03560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.73	± .03	14.73	✓			
Φ.507	+ .000 - .001	.507	✓			
.250	± .010	.250	✓			
.188	"	.188	✓			
.250	"	.250	✓			
.275	"	.275	✓			
2.465	"	2.465	✓			
12.682	"	12.682	✓			
14.73	± .03	14.73	✓			
4.481	± .010	4.481	✓			
5.633	"	5.633	✓			
.188	"	.188	✓			
R.032	"	.032	✓			
.500	"	.500	✓			
Φ.507	+ .000 - .001	.507	✓			
Φ.196	+ .005 - .001	.196	✓			
.385 X .100"	± .010	.385	✓			
Φ 1000	± .010	1.000	✓			
2.000	"	2.000	✓			
1.000	"	1.000	✓			
.375	"	.375	✓			
R.13	± .03	.13	✓			
.850	± .010	.850	✓			

Measured by: 36	Audited by: J1	Prototype Approval: [Signature]
Date: 07.06.01	Date: 07/06/01	Date: 07.06.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1.0000

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

06/06/2007

